

Work Order ID 117791

May-02-14 12:47:36 PM

No print - Need Monday May 5
117791

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Item ID: D2741-NP Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Blade (No paint)
 Start Date: 5/02/14 Start Qty: ~~10.00~~ ***10*** Cust Item ID:
 Required Date: 5/06/14 Req'd Qty: ~~10.00~~ ***10*** Customer:
 Reference:

Approvals: Process Plan: *[Signature]* Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2741	E								

105 0.00
105
 Large Fab Memo 0.00 20 EL 14-5-5
 Large Fab PULL FROM W/O 115522
~~20~~ X D2741

220 0.00
220
 Packaging Memo 0.00 20 EL 14-5-5
 Packaging RE-IDENTIFY AS
 D2741-NP USING NEW B/N *gic h.*

230 0.00
230
 QC Memo 0.00 MLJ 14-05-09
 Quality Control *ME 14-5-08*

Picklist Print

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Work Order ID: 117791

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Parent Item: D2741-NP

D2741-NP

Parent Item Name: Blade (No paint)

Start Date: 5/02/14

Required Date: 5/06/14

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP REV:A 14.04.08 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2741		Manufactured	No				Each	30.0000		10			

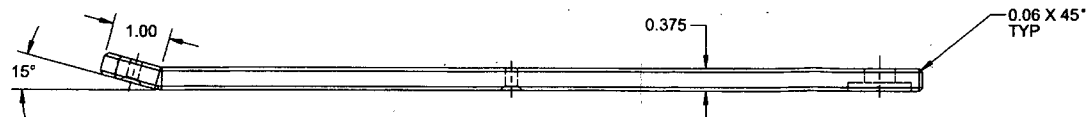
D2741

Blade

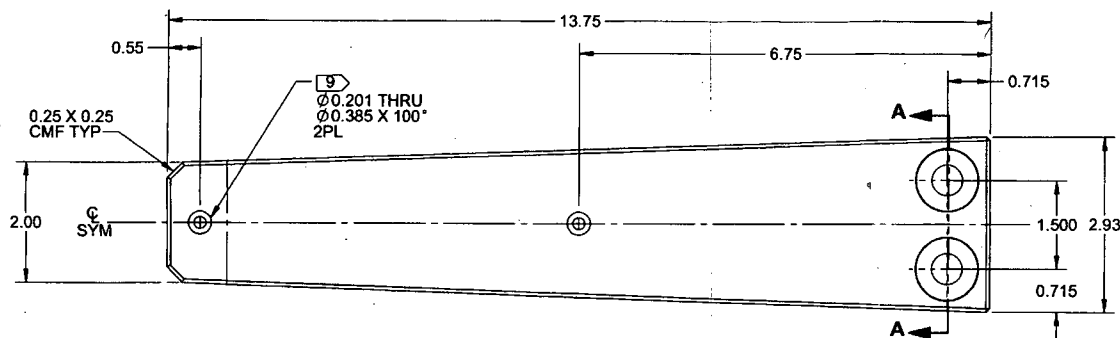
B 145-5

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	11	
100664	5	
85480	1	
98323	5	
ST466	19	
107206	2	
113640	17	

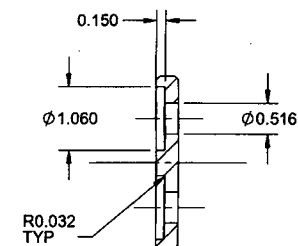
115522 x 20



D2741 BLADE
(MAKE FROM D2741F)



D2741F FLAT PATTERN



SECTION A-A

RELEASED
2014-04-04

NOTES:

- 1) MATERIAL: AISI 4130N STEEL BAR PER MIL-S-6758 OR AMS 6345/6348/6370/6528
REF DART SPEC. M4130N-B0.500X3.000
- 2) FINISH: D2741: POWDER COAT "WHITE" (4.3.5.2) PER DART QSI 005 4.3
D2741-NP: NO PAINT
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.030 TO 0.060 MAX
- 6) IDENTIFICATION: WITH DART P/N "D2741" OR D2741-NP, AND B/N "BXXXXX", PER DART QSI 044 6.1 (FINE POINT PAINT MARKER)
- 7) WEIGHT: 3.3 lbs
- 8) HEAT TREAT TO MIN. ULTIMATE TENSILE STRENGTH = 152 ksi AND MIN. YIELD TENSILE STRENGTH = 141 ksi
PER MIL-S-6758 OR AMS2759/1E AFTER MACHINING.
ACCEPTABLE TO VERIFY TENSILE STRENGTH BY HARDNESS TEST PER ASTM E18 TO 34-40 HRC.
- 9) OPTIONAL: ONLY REQUIRED WHEN MAKING D350-636-215/-216/-217/-218, NOT APPLICABLE ON D2741-NP.

DESIGN	DS	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	DB		
CHECKED	AP	DRAWING NO.	REV. 8
MFG. APPR.	AP	D2741	SHEET 1 OF 1
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	BLADE	NTS
DATE	13.08.29	<small>COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	